

Work Order ID 50812

July 22, 2009 2:57:04 PM

Req'd latest 31/07



Page 1

Item ID: D2229

Accept



Setup

Start



Revision ID: B

Stop



Item Name: Doubler

Start Date: 7/24/09 Start Qty: 24.00



Cust Item ID:

Required Date: 7/28/09 Req'd Qty: 24.00



Customer:

Reference:

Approvals: Process Plan:



Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
----------	--------------

D2229	Rev B
-------	-------

100



FLOW WATER JET

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D2229

Dwg Rev: B | Prog Rev: B | 2-

Deburr if necessary

HB 9-7-22

EB 09/07/22

34

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

HB 9-7-22

34

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

⇒ 50210763

counted
x34 f

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Cust Item ID:

Required Date: 7/28/09 Req'd Qty: 24.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID**

130



Small Fab

Small Fab

**Operation
Description**

Small Fab

Memo

Deburr. No sharp edges

**Set Up/
Run Hours**

0.00

0.00

**Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

0.00

BL0907-23

(34)

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

=> 8090724

Counted
(34)

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

=> 8090724

8

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Item ID: D2229

Accept



Setup Start



Revision ID: B

Stop



Item Name: Doubler

Start Date: 7/24/09 Start Qty: 24.00



Cust Item ID:

Required Date: 7/28/09 Req'd Qty: 24.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID**

160



Packaging

Packaging

**Operation
Description**Identify as per dwg & Stock Location: 21Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

PC 17/24 (34)

09/07/27 HJ

u 9.7.24

Picklist Print

July 22, 2009 2:57:03 PM

Page 1

Work Order ID: 50812



Parent Item: D2229RevB



Parent Item Name: Doubler

Start Date: 7/24/09

Required Date: 7/28/09

Comments:

Start Qty: 24.00

Required Qty: 24.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased		No		100	sf	158.6888	1.3162			

2024-T3 .063 sheet

Warehouse

Location

Main Warehouse

MAT	158.6888421	
102942	1.5	
105916	3.69	
106223	1.47	
109463	24.2	
110980	15.45	
111787	110.378842	
19059	2	

Loc Qty

Loc Code

111787 1B9-7-22

DART AEROSPACE LTD	Work Order:	50812
Description: DoulBER	Part Number:	12224
Inspection Dwg: 12224 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>BB</u>	Audited by: <u>J</u>	Prototype Approval: <u>u</u> / <u>7</u>
Date: 9-7-22	Date: 09/07/22	Date:

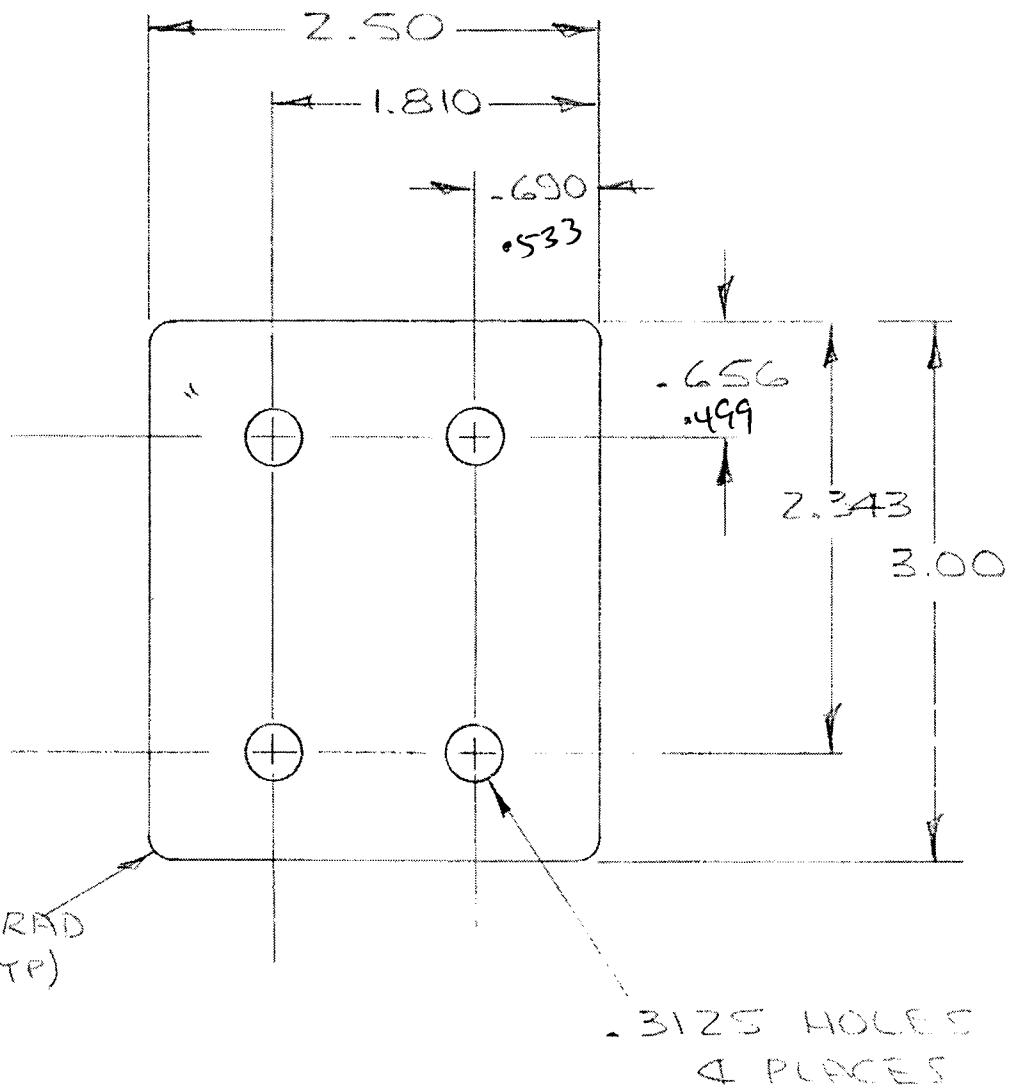
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART

3/16/94
DART

DRAWN BRADLEY 94-3-28	DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA		
DESIGN BRADLEY 94-3-28	DRAWING NO. D2229	REV. B	SHEET 1 OF 1
	TITLE DUBLER		

A	NEW ISSUE	94/3-28	4
B	ALUDINE w/ ANODIZE	97/1/86	5



MATERIAL: 2014-T3 ALUMINUM
.063 THICK

FINISH: ALUDINE PER ASI 005-4.1